



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4382-1
Job Sheet 169486



Part No: D4382-1

Job Qty: 10 ea

Part Name: Angled Bearpaw Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/12/17

Job Tracking No:

Due Date: 12/18/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Helicopter Maintenance Corporation (CHMAI01)

2465 Commerce Avenue Boise, ID, 83705 USA ph:(208) 344-6521

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		12/16/17	0.00	0.00	Start Up Waterjet		on 17/12/13
100	Waterjet	10 pcs		12/16/17	0.00	0.54	Waterjet1		on 17/12/13
110	QC	10 pcs		12/16/17	0.00	0.00	QC2 Waterjet-3		on 17/12/13
120	QC	10 pcs		12/16/17	0.00	0.00	QC8-4		38
130	Brake NC	10 pcs		12/18/17	0.00	1.29	Brake NC 1		3-89DA
140	QC	10 pcs		12/18/17	0.00	0.00	QC5		38
150	Packaging	10 pcs		12/18/17	0.00	0.00	Packaging3	SRL	51543
160	QC21-SA	10 Ea		12/18/17	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary

Descriptions: 120 - QC8- Inspect parts - second check

130 - Form as per dwg DT9709

140 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg & Stock Location: _____

160 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S14GA	1	18	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Angled Bearpaw Clamp	0.266Inches $\pm$ 0.010	0.276 0.256		
2	Angled Bearpaw Clamp	0.370Inches $\pm$ 0.030	0.400 0.340		
3	Angled Bearpaw Clamp	0.130Inches $\pm$ 0.030	0.160 0.100		
4	Angled Bearpaw Clamp	0.750Inches $\pm$ 0.030	0.780 0.720		
5	Angled Bearpaw Clamp	0.380Inches $\pm$ 0.030	0.410 0.350		
6	Angled Bearpaw Clamp	0.230Inches $\pm$ 0.030	0.260 0.200		

DART
AEROSPACE
S021211



Angled Bearpaw Clamp

PART NO: D4382 - 1

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 12/13/17

Job No: 169486

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

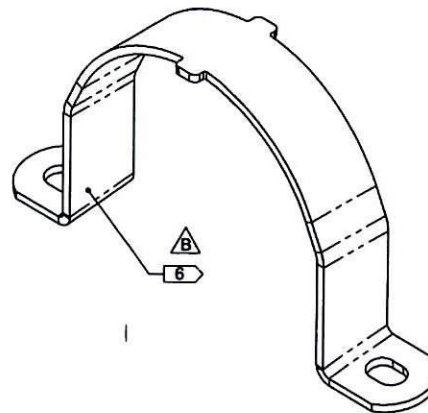
TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

7	Angled Bearpaw Clamp	7.940Inches $\pm$ 0.030	7.970 7.910
8	Angled Bearpaw Clamp	0.080Inches $\pm$ 0.010	0.090 0.070

Plex 12/12/17 4:39 PM dart.poulin.mario



D4382-1 ANGLED BEARPAW CLAMP B

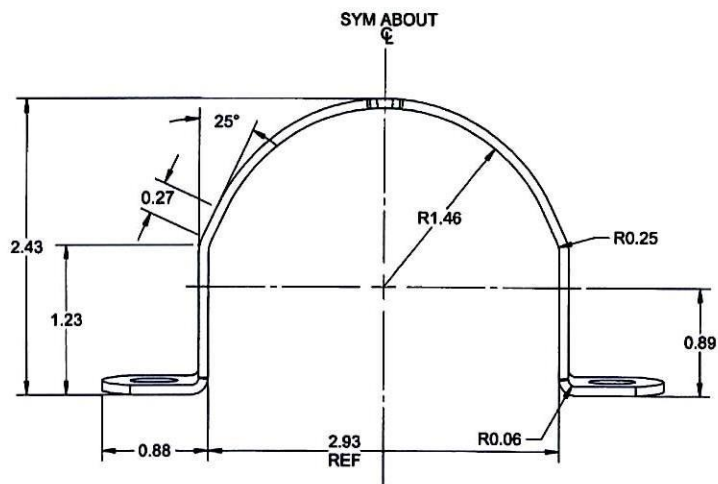
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4382-1" AND S/N "SXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 0.13 lbs

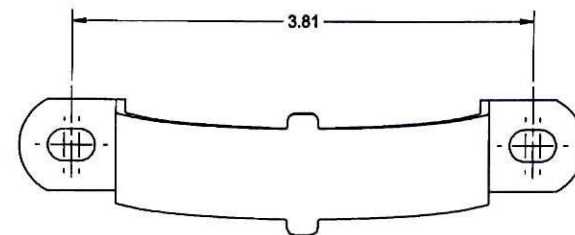
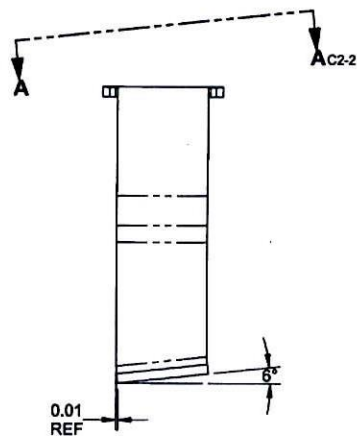
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2017-12-12
ECN 17-744

APPROVED

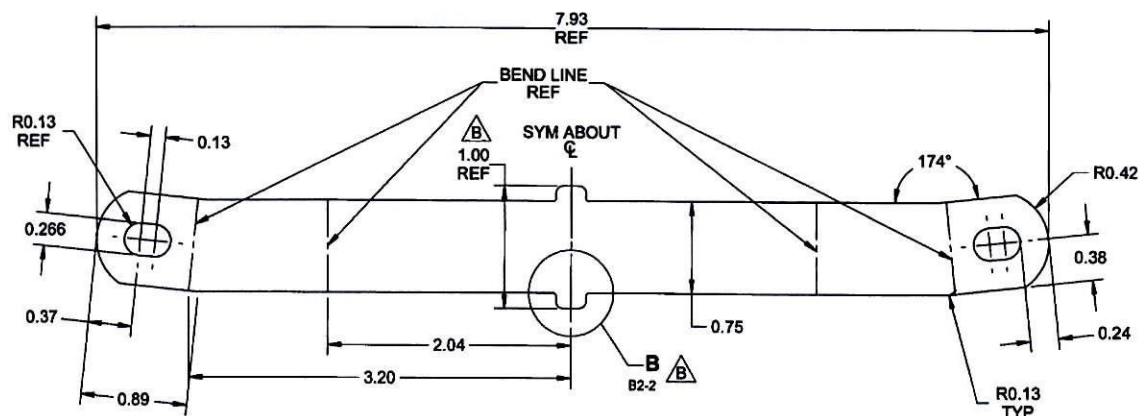
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A	NEW ISSUE		AJS	11.03.28
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	VS	DRAWING NO.	REV. B	
MFG. APPR.	JFS	D4382	SHEET 1 OF 2	
APPROVED	HS	TITLE	SCALE	
DE APPR.	DS	ANGLED BEARPAW CLAMP	NTS	
DATE	17.11.07			
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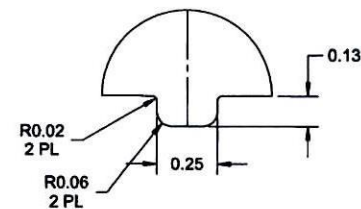
D4382-1 ANGLED BEARPAW CLAMP



VIEW A-A D3-2



**D4382-1F ANGLED BEARPAW CLAMP
(FLAT PATTERN)**



DETAIL B B2-2
2 PL

APPROVED	DESIGN	AJS	DART AEROSPACE LTD	
	DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	VS	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D4382	SHEET 2 OF 2
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	ANGLED BEARPAW CLAMP	NTS
	DATE	17.11.07	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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